

Work Order ID 67479

Tuesday, March 22, 2011 2:41:26 PM

PRELIMINARY ISSUE

PRELIMINARY
ISSUE

Page 1

Item ID: D4323-19

Accept

Revision ID: PRELIM

Item Name: Cabin Side Post, LH

Start Date: 3/22/2011 Start Qty: 1.00

Required Date: 3/23/2011 Req'd Qty: 1.00

Reference:

Cust Item ID:

Customer:

POSITIVE
RECALL

Approvals:

Process Plan:

Date: 11-03-22 Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4323

PAL

100

0.00

HandThermo

Memo

0.00

Hand Finishing Thermoforming

1-Cut Sheet to required Blank size

11/03/22

105

0.00

HandThermo

Dry Material

Memo

0.00

Hand Finishing Thermoforming

Dry Sheet as per QSI022 KYDEX

Temp: 150° F

Time IN: 4:00 pm

11/03/21

Time OUT: 7:00 am

11/03/22

11/03/22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Setup Start



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Stop



Start Date: 3/22/2011 Start Qty: 1.00



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Required Date: 3/23/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

110

0.00



Thermoform

Memo

0.00

Thermoforming Machine

1-Machine Set-Up
2-Pre-heat Tool to required temp.
3-Thermoform as per Dwg and Folio #FTA101 using tool DT9728
Dwg Rev: PAS
Folio Rev: A

(x1)

x1

Dh

11/03/22

PTO →

120

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

Visually inspect part for proper formation and texture

Dh

11/03/22

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

Parts not trained
to be Done Q
stage.
Do not mixch dy
Sullos/23

W/O:		WORK ORDER CHANGES					
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Part No: D 4323-19 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NCR: 67479		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
11/03/02	110.	Heavy Mould Marks showing through thin part.	↓ 11/03/02 CS 042	Scrap 1 part. Re-sand mould & form 1 new part.	wh. 11/03/02	S 11/03/02	↓ 11/03/02	S 11/03/02

NOTE: Date & initial all entries

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Page 3

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Setup Start



Revision ID: PRELIM

Item Name: Cabin Side Post, LH

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Start Date: 3/22/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 3/23/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____




Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140 		0.00	N/A.	see attached.					Wh 11/03/23
HandThermo	Memo	0.00							
Hand Finishing Thermoforming	1-Trim to finished dimensions as per Dwg								
150 	QC2- Inspect parts off machine FAI/FAIB	0.00	W						
QC	Memo	0.00							
Quality Control	Complete FAI document								
160 	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									

~~W 3.22.11~~

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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Page 4

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Item Name: Cabin Side Post, LH

Stop



Start Date: 3/22/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 3/23/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

Recall

0.00

Packaging

SO 109507

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

RD2370

POSITIVE RECALL

EFFECTIVE 11/3/09 AUTH

RELEASED 11/3/09 DATE 11/3/09

U 11.0329

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

Tuesday, March 22, 2011 2:41:32 PM

Page 1

Work Order ID: 67479

Parent Item: D4323-19

Parent Item Name: Cabin Side Post, LH

Start Date: 3/22/2011

Required Date: 3/23/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: Rev. A New Issue 11/03/22 DL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MKYD6185S.080-P3- 62015		Purchased	No			100	sf	948.0376	13.5416	14.25432			



6185 KYDEX .080"



Location

therm

Loc Qty

948.037564

81.189115

866.848449

Loc Code

109703

116576

DL
11/03/23

28 5086 sq ft

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Daryl Leger

From: Daniel Campbell [dcampbell@dartaero.com]
Sent: Wednesday, March 23, 2011 9:21 AM
To: 'Daryl Leger'
Cc: Harvey Siemens
Subject: D4323 Parts

Hi Daryl,

As per our conversation this morning, you can release the D4323-1/-2/-19/-20 parts for shipping to YYC without having trimmed them first. This means that the dimensions will not match the drawings, but since these are essentially "prototype" parts, they will be trimmed to fit here in YYC. The drawings will be modified as per the final fitting and trimming.

Cheers.

Daniel Campbell
Mechanical Engineer
DART Aerospace Ltd.

P: 403-717-0325
F: 403-717-1288
E: dcampbell@dartaero.com
W: www.dartaero.com
M: 1060 McTavish Road, NE, Calgary, Alberta, T2E 7G6

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3/23/2011

Daryl Leger

From: Daryl Leger [dleger@dartaero.com]
Sent: Wednesday, March 23, 2011 10:15 AM
To: 'Daniel Campbell'
Cc: 'Harvey Siemens'; Linda Lacelle (llacelle@dartaero.com)
Subject: RE: D4323 Parts

Dan

I will do my best to ship the parts today.

Please note: If the parts are deemed acceptable, please notify the proper authority at Dart so that the positive recall can be removed on the Work Orders.

Daryl

From: Daniel Campbell [mailto:dcampbell@dartaero.com]
Sent: Wednesday, March 23, 2011 9:21 AM
To: 'Daryl Leger'
Cc: Harvey Siemens
Subject: D4323 Parts

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Cheers.

Daniel Campbell
Mechanical Engineer
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3/23/2011

